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SOLUBILITY CHARACTERISTICS OF A METHACRYLATE COPOLYMER

MARIE K. POTTS
POLYMER RESEARCH BRANCH

May 1990

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ABSTRACT

Solubility maps in several solubility coordinate systems have been constructed to determine regions of solubility for a methacrylate copolymer. The general methodology followed was that of ASTM D 3132 Test Method for Solubility Range of Resins and Polymers. Over 90 individual solvents and solvent mixtures were tested as solvents for the copolymer in the concentration range 5% - 7.5% w/v. A database on the solubility characteristics of common solvents was created to store and utilize the information. Solvent maps were formulated using the solubility parameter-hydrogen bond index-dipole moment system, the Hansen solubility parameter system, and the Teas fractional cohesion parameter system. Each system is primarily empirical in nature, but has varying degrees of theoretical justification.

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INTRODUCTION

A semi-dilute (8g/dL) multi-component solution is under investigation in which the solute is a high molecular weight copolymer serving as a viscoelastic additive and the three cosolvents are components which undergo further reaction. It is of critical importance that the isobutylmethacrylate-co-t-butylaminoethylmethacrylate (iBMA/tBAEMA) copolymer remain soluble during the reaction process to ensure complete reaction. The end-use requirements mandate that the copolymer remain soluble in the resulting reaction product in order to provide the desired viscoelastic properties. In addition, the copolymer must remain soluble in the reactants for long periods of time before use. Thus, the solubility of the copolymer in the original reactants and in the final reaction product is critical.

The entire solubility range (as determined by two-dimensional plots of various solvent properties) of the copolymer was determined to assure that the coordinates of the ternary solvent system and of the final reaction product, the compositions of which are proprietary, lie well within the boundaries of the soluble portion of the solubility phase diagram.

The general solubility test method outlined in ASTM D 3132¹ has been used to assess the solubility range of the copolymer in various organic solvents and solvent mixtures. The solvent mixtures, however, have not been limited to those listed in the test method. The resulting solubility data has been plotted using Hansen cohesion parameters and Teas fractional cohesion parameters in addition to the Hildebrand solubility parameter/dipole moment/hydrogen bond index method described in the ASTM method.

The Hildebrand solubility parameter, (δ), is defined² as the square root of the cohesive energy density, or cohesive pressure,

$$\delta = c^{1/2} = (-U/V)^{1/2} \quad (1)$$

where U is the internal energy of the molecule and V is its molar volume. This can be envisioned as the amount of energy required to disperse the molecules in the liquid state, similar to what occurs in vaporization. This solubility parameter is also referred to as a cohesion parameter,³ and may be experimentally determined from the molar enthalpy of vaporization and the molar volume via $U = \Delta H - RT$. The units of δ are generally $(\text{MPa})^{1/2}$ or $(\text{cal/cm}^3)^{1/2}$.

The ASTM D 3132 method is based on correlating the Hildebrand parameter with the hydrogen bonding ability and the dipole moment of a solvent to determine regions of solubility and immiscibility for polymers. One method of quantifying the hydrogen bonding ability of a solvent (hydrogen bond index, γ) was developed by Crowley et. al.⁴ and subsequently has been designated with the subscript "C". This parameter is defined by

$$\gamma_C = \Delta\nu/10 \quad (2)$$

where $\Delta\nu$ is the spectroscopic shift (in wavenumbers) observed for the O-H band in the IR spectrum of an alcohol in a solvent of interest, relative to the spectrum of the neat alcohol.

1. ASTM D 3132-84 *Standard Test Method for Solubility Range of Resins and Polymers*, American Society for Testing and Materials, Philadelphia, PA, 1984.
2. HILDEBRAND, J. H., and SCOTT, R. L. *Solubility of Non-Electrolytes*, 3rd Edition, Reinhold, New York, 1950, Dover, New York, 1964.
3. BARTON, A. F. M. *CRC Handbook of Solubility Parameters and Other Cohesion Parameters*, CRC Press, Inc, Boca Raton, Florida, 1983.
4. CROWLEY, J. D., TEAGUE, G. S., Jr., and LOWE, J. W. *A Three-dimensional Approach to Solubility*. J. Paint Technol., v. 38, 1966, p. 269.

The stronger the hydrogen bonding between the solvent and the hydroxyl hydrogen, the weaker the O-H bond in the alcohol, and the lower is the frequency of the vibration. The third parameter used in the ASTM method is the dipole moment of the solvent (in Debye units).

Hildebrand's original solubility parameter² was intended for non-polar, non-associating molecules, but has been used for all molecules anyway. Hansen⁵ extended the Hildebrand solubility concept to a three-component solubility parameter composed of dispersive (non-polar), polar, and hydrogen bonding contributions. The total solubility parameter (δ_t) is essentially equivalent to the Hildebrand parameter, although minor differences exist due to the values being determined by different methods. The Hansen components are related to one another through the equation

$$\delta_t^2 = \delta_d^2 + \delta_p^2 + \delta_h^2, \quad (3)$$

where the subscripts d, p, and h refer to the dispersive, polar, and hydrogen bonding components, respectively. The dispersive contribution of a molecule is usually estimated by comparing the δ value of a polar molecule with the δ value of a non-polar molecule of similar size and shape (homomorph method⁶). This dispersive contribution is then subtracted from the total solubility parameter, and the remainder can be divided into hydrogen bonding and polar contributions using various semi-empirical approaches.

Although Hansen's approach is somewhat more theoretical in nature, in terms of practical applications (i.e., determining solubility ranges for polymers), it does not appear to offer any significant advantage over that of the ASTM Hildebrand parameter-hydrogen bond index system. The only advantage to either system would probably be the availability of data for the particular solvents of interest.

Another three-component cohesion system was developed by Teas⁷ using *fractional* cohesive parameters. This system is based on the idea that the total cohesion parameter is composed of the same three components as proposed by Hansen, but the fraction of the total cohesion parameter describing each of the three components is significant, as opposed to the actual value of the cohesion parameter. In other words, the total cohesion parameter for all liquids is the same, but the contribution arising from the three forces (polar, dispersive, and hydrogen bonding) differs from molecule to molecule. One advantage of this method is that the three components can be plotted on a triangular chart in two dimensions, whereas the other systems described require three dimensions (or two-dimensional contour plots) to view the effects of three parameters simultaneously. However, there is little theoretical justification for this type of analysis, considering the variation in the total solubility parameters, as can be seen in Appendix A.

5. HANSEN, C. M. *The Three-dimensional Solubility Parameter - Key to Paint Component Affinities. I. Solvents, Plasticizers, Polymers and Resins*. J. Paint Technol., v. 39, 1967, p. 104.
6. BROWN, H. C., BARBARAS, G. K., BERNEIS, H. L., BONNER, W. H., JOHANNENSEN, R. B., GRAYSON, M., and NELSON, K. L. *Strained; Homomorphs. 14. General Summary*. J. Am. Chem. Soc., v. 75, 1953, p. 1.
7. TEAS, J. P. *Graphic Analysis of Resin Solubilities*. J. Paint Technol., v. 40, no. 19, 1968, p. 516.

EXPERIMENTAL

Materials

The iBMA/tBAEMA copolymer was obtained from Polysciences (Lot #CM1-120). The composition of the copolymer was determined to be 77:23 from ^{13}C NMR and an average molecular weight of 2.9×10^6 has been estimated by aqueous GPC and light scattering.

The following solvents were used individually and in the solvent mixtures:

Acetone, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
Acetonitrile, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
n-Butanol, certified grade. Fisher Scientific. Used as received.
2-Butoxyethanol, 99%. Aldrich Chemical Company, Inc. Used as received.
Cyclohexane, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
Cyclohexanone, technical grade. Distilled before use.
1,2-Dichloroethane, certified grade. Fisher Scientific. Used as received.
Dichloromethane, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
Diisopropyl ether, anhydrous, 99%. Aldrich Chemical Company, Inc. Used as received.
Dimethylsulfoxide, certified grade. Fisher Scientific. Used as received.
Ethanol, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
2-Ethyl-1-hexanol, 99%. Aldrich Chemical Company, Inc. Used as received.
Ethylene Carbonate, 98%. Aldrich Chemical Company, Inc. Used as received.
n-Heptane, distilled in glass (UV grade). Burdick & Jackson Laboratories, Ltd. Used as received.
n-Hexane, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
Methanol, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
N-Methylpyrrolidone, GC grade. Burdick & Jackson Laboratories, Ltd. Used as received.
Nitrobenzene, certified grade. Fisher Scientific. Used as received.
Nitromethane, 96%. Aldrich Chemical Company, Inc. Used as received.
n-Pentane, GC grade. Caledon Laboratories, Ltd. Used as received.
Phenol. Aldrich Chemical Company, Inc. Used as received.
n-Propanol, Certified ACS grade. Fisher Scientific. Used as received.
Pyridine, reagent grade. British Drug House, Ltd. Used as received.
Tetrahydrofuran, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.
Toluene, distilled in glass (UV grade). Caledon Laboratories, Ltd. Used as received.

Procedure

The copolymer (0.15 ± 0.01 g) was weighed into 4 mL glass vials fitted with teflon-lined caps. The solvent components were delivered into the vials individually via burets or graduated pipets (the total volume of solvent added was 2 to 3 mL, to keep the copolymer solution concentration between 5 and 7.5 g/dL). The vials were then tightly capped and put into a drum tumbler rotating end-over-end (approximately 14 rpm) for 48 to 72 hours. (The ASTM method specifies 48 hours at 1 to 5 rpm, however, at the higher mixing rate used in this study, some of the more viscous solutions required more mixing time.) After mixing, the solutions were analyzed visually for solubility and characterized as follows:

Soluble (S): Transparent solutions of one phase.

Borderline (B): One phase which appears cloudy or turbid.

Insoluble (I): Two distinct phases.

The solution composition (by volume percent of solvent components) was recorded along with the solubility designation for each mixture. The solubility parameters were calculated for each mixture and plotted in the three different coordinate systems previously discussed.

RESULTS AND DISCUSSION

Database

A solubility database has been created for the individual solvent components used in this study. This database contains the following information:

Solvent names (up to five names or abbreviations).

Molar volume (g/ml).

Hildebrand solubility parameter (cal/cm³)^{1/2}.

Hydrogen bond index (Crowley parameter, wavenumbers).

Dipole moment (Debye units, 3.336 x 10⁻³⁰ C-m).

Hansen dispersion solubility parameter (cal/cm³)^{1/2}.

Hansen polar solubility parameter (cal/cm³)^{1/2}.

Hansen hydrogen bonding solubility parameter (cal/cm³)^{1/2}.

Teas fractional dispersion cohesion parameter (x100, Unitless).

Teas fractional polar cohesion parameter (x100, Unitless).

Teas fractional hydrogen bonding cohesion parameter (x100, Unitless).

This information is listed in Appendix A for the solvents used in this study. The solubility data stored in this database are used to calculate the solubility constants for the solvent mixtures based on the solubility constants of the individual components and their volume fraction in the mixture. The calculated solubility constants are defined as

$$S = (\Phi_1 s_1 + \Phi_2 s_2 + \Phi_3 s_3) / \Sigma \Phi_i \quad (4)$$

where S is the calculated solubility constant for the mixture of i solvent components (e.g., S could be the Hildebrand solubility parameter, the Hansen polar parameter, etc.), s_i is the solubility constant for each solvent component and Φ_i is its corresponding volume fraction. The volume fraction of component i is defined by

$$\Phi_i = V_i x_i / (V_1 x_1 + V_2 x_2 + V_3 x_3). \quad (5)$$

The single and multi-component solvents used in this study are listed in Appendix B, along with the experimentally determined solution solubilities (soluble, borderline, or insoluble), as well as the solubility constants as calculated from Equations 4 and 5. The different solubility phase diagrams or *maps* were constructed from the information in Appendix B, as described in the following section. Most of the solvent mixture compositions were obtained

from a previous solubility study⁸ on a similar polymer, poly(methylmethacrylate-co-isobutylacrylate-co-ethylacrylate), and others were designed to fill in the undefined areas in the diagram.

Solubility Phase Diagrams

Figures 1 through 7 show two-dimensional plots of the various solubility parameters indicating general areas of solubility and insolubility. Figure 1, in which the hydrogen bond index is plotted against the Hildebrand parameter, is the most common type of solubility map. The particular solvents and solvent mixtures in this study were chosen such that a closed solubility region would be determined on this type of plot (i.e., when areas on the plot were undefined, solvent mixtures with the appropriate coordinates were tested). Because the coordinates were chosen for a particular solubility system, the solubility regions on the other maps are not as clearly defined. Figures 2 and 3 show the dipole moment versus the Hildebrand solubility parameter and the hydrogen bond index, respectively. Figures 4 through 6 show the various Hansen solubility parameters (dispersion, hydrogen bonding, and polar) plotted in two dimensions.

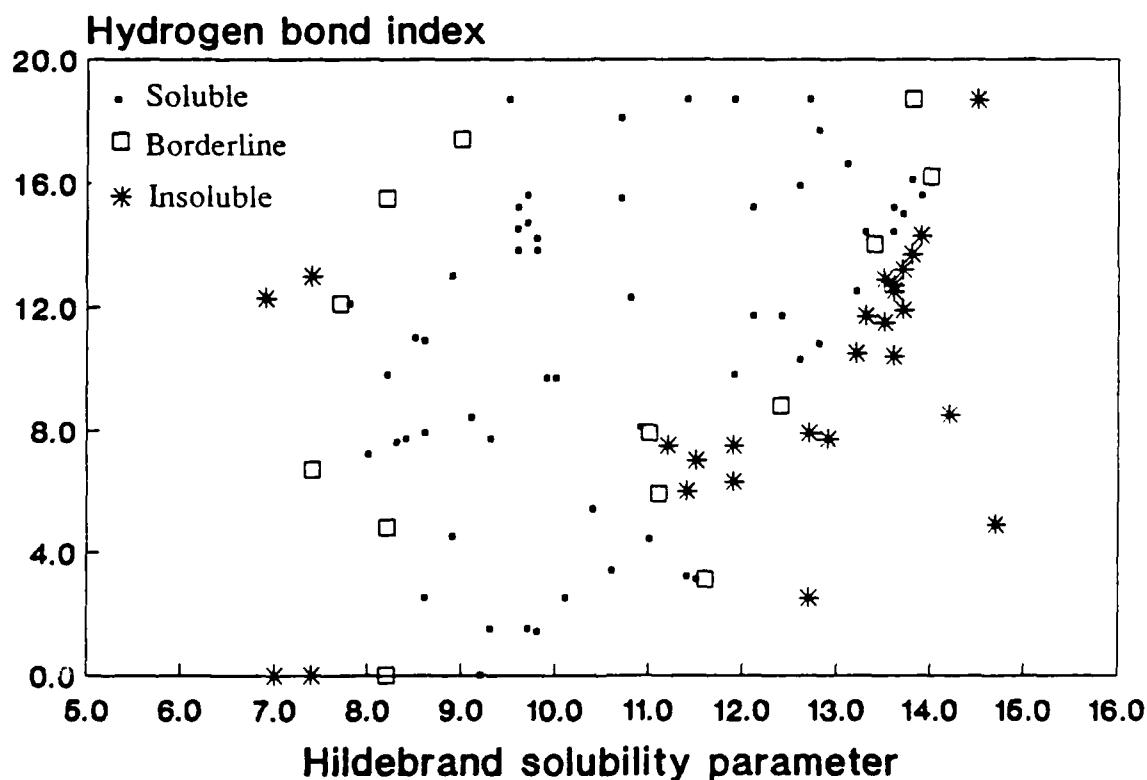


Figure 1. Plot of hydrogen bond index versus Hildebrand solubility parameter.

8. SHUELY, W. J., and SCOTT, L. G. *The Polymer Solubility Phase Diagram for the Methylmethacrylate Copolymer Acryloid K125*. ARCSL-TM-80008, 1980.

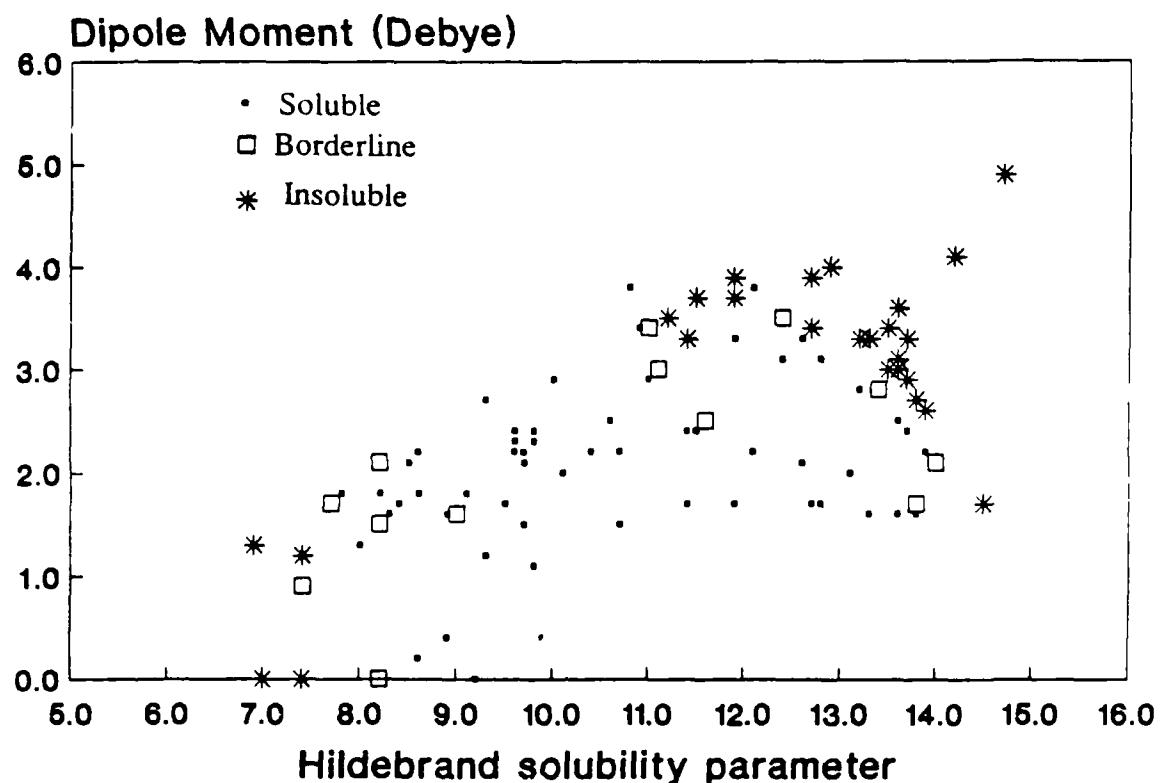


Figure 2. Plot of dipole moment versus Hildebrand solubility parameter.

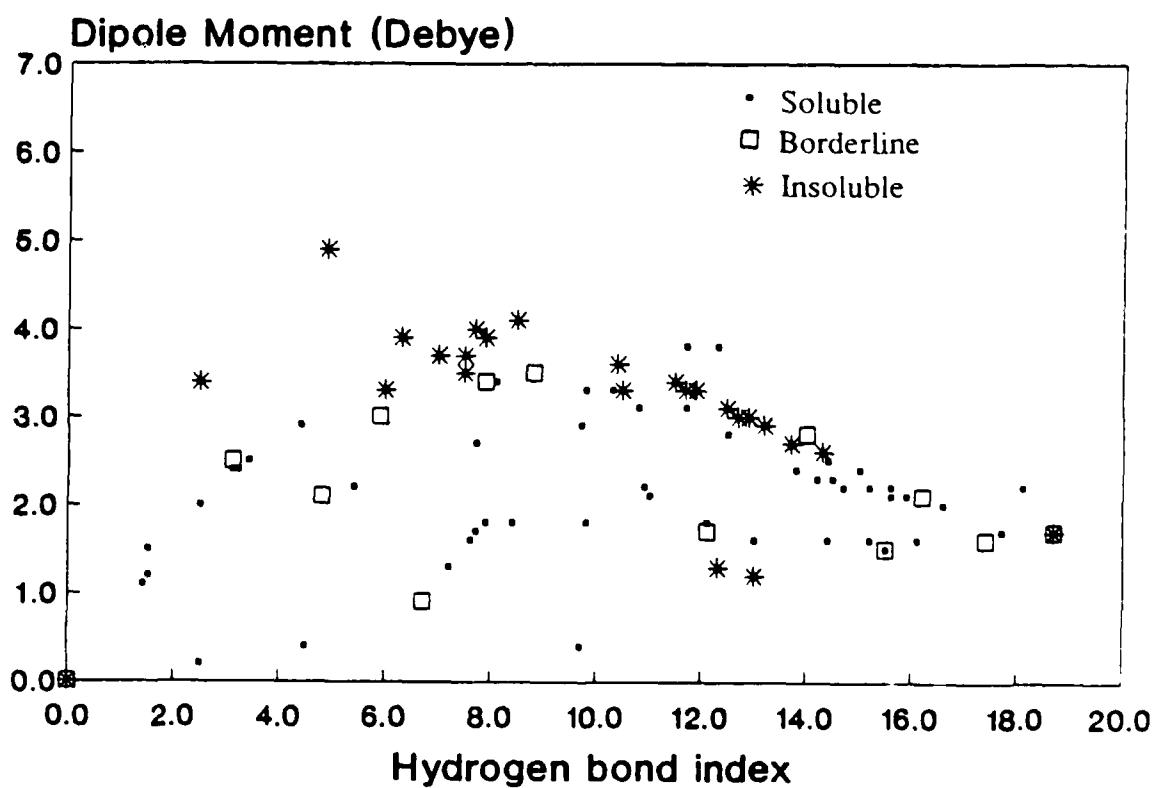


Figure 3. Plot of dipole moment versus hydrogen bond index.

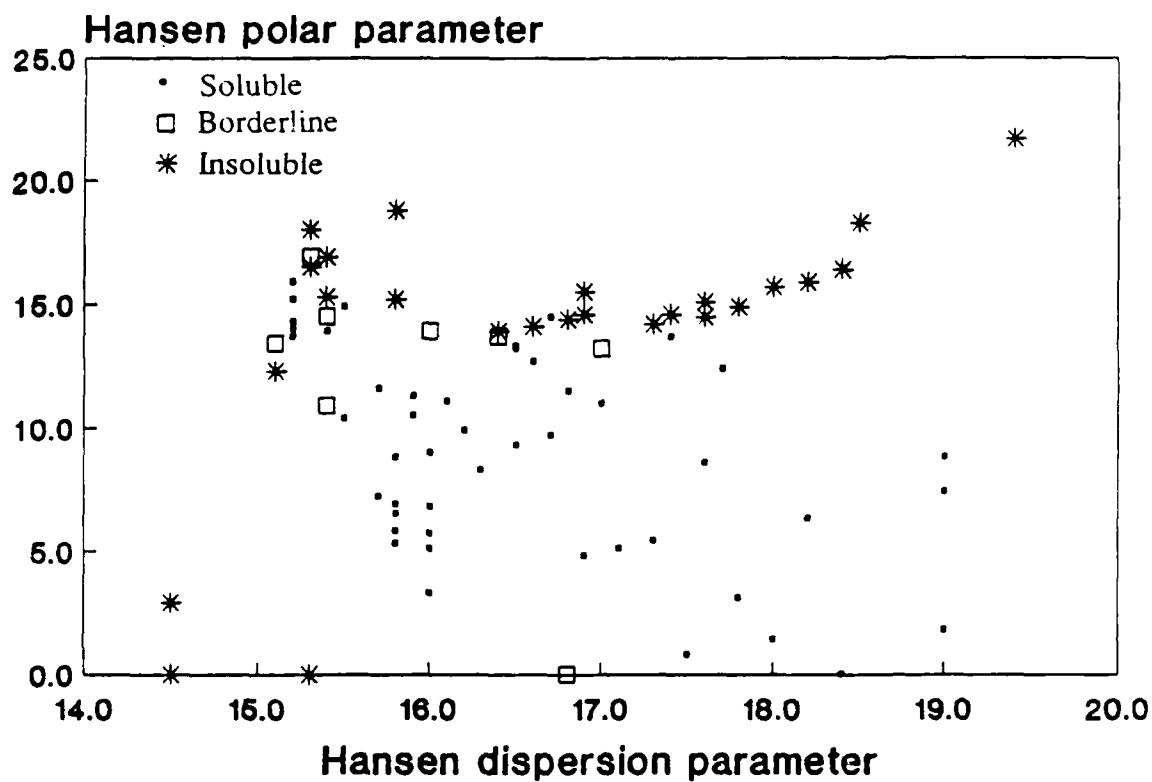


Figure 4. Plot of Hansen polar parameter versus dispersion parameter.

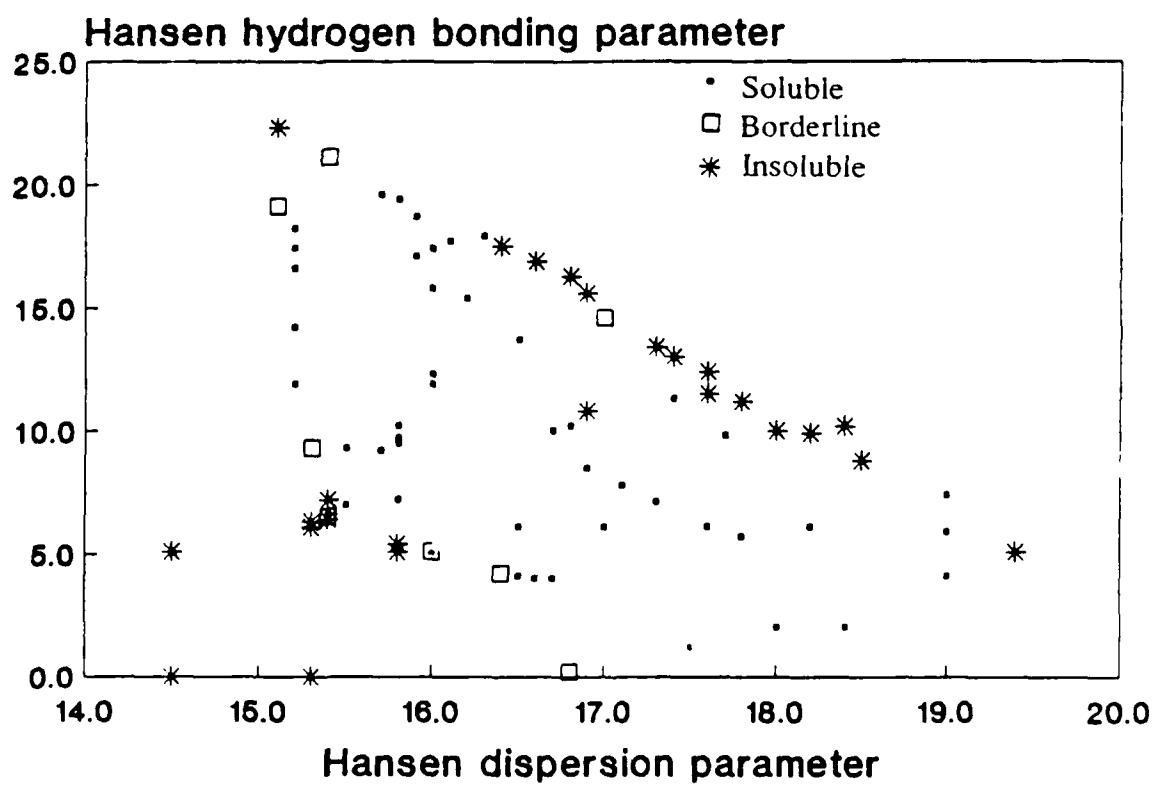


Figure 5. Plot of Hansen hydrogen bonding parameter versus dispersion parameter.

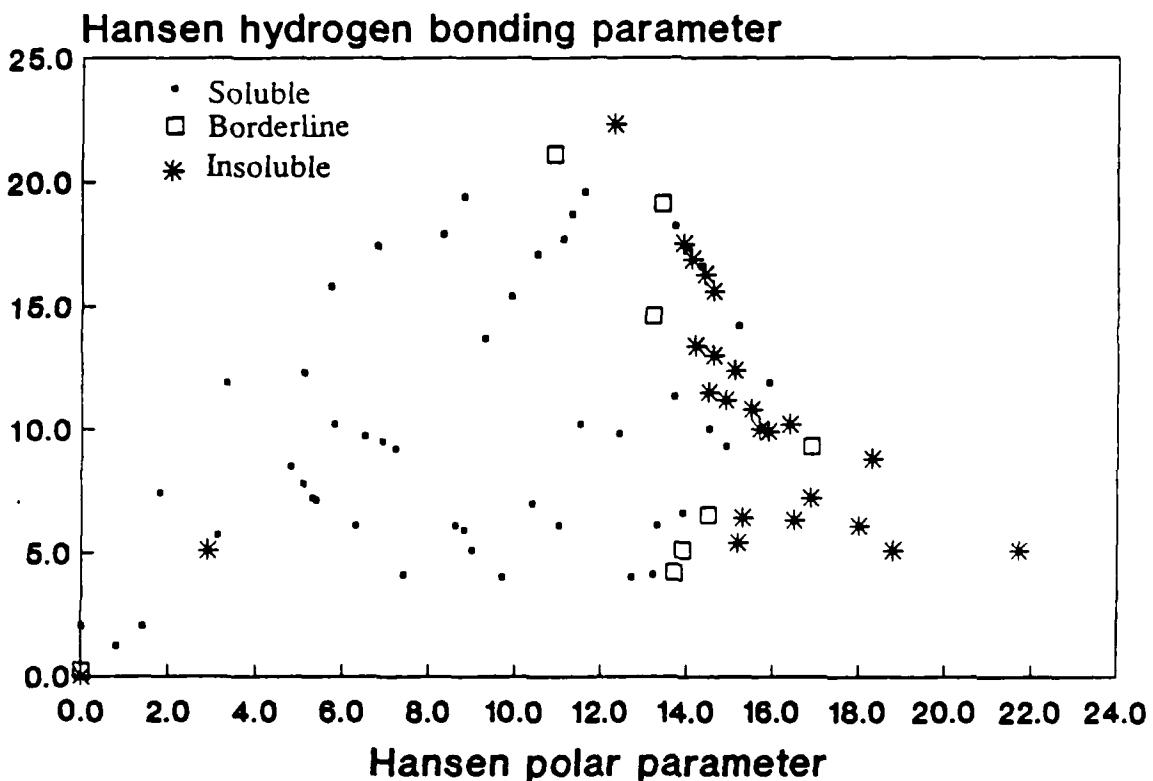


Figure 6. Plot of Hansen hydrogen bonding parameter versus polar parameter.

Three-dimensional solubility maps are probably the most appropriate way to analyze a solubility region, although they are difficult to construct. By adding a third dimension to Figure 1 (the dipole moment), Figures 1 through 3 could be combined for a single map. The same type of analysis could be applied to the Hansen cohesion system with Figures 4 through 6. Alternatively, contour plots can be drawn on two-dimensional maps. This requires more planning in selecting the solvent mixtures, however, noting that the third dimension values must be at certain fixed values. Neither three-dimensional nor contour plots have been constructed for this study.

Figure 7 shows the Teas three fractional cohesion parameters plotted on a triangular chart in two dimensions, as explained in the Introduction. This type of analysis appears to be almost three-dimensional in nature, but since the three-fractional parameters sum to unity, only two are actually independent variables (e.g., $f_h = 1 - f_d - f_p$). The presence of the third variable, however, changes the values of the other two and, thus, it has some influence on the plot. The points on a triangular plot such as this are determined by constructing lines of constant solubility for each axis by drawing lines at equal increments along the axis parallel to the adjoining axis, as shown in Figure 8. The intersection of these *iso* lines for each axis represents the point of interest. The point corresponding to ethyl ether with the coordinates (f_d , f_p , and f_h) equal to (0.64, 0.13, and 0.23) is indicated in Figure 8 by a circle.

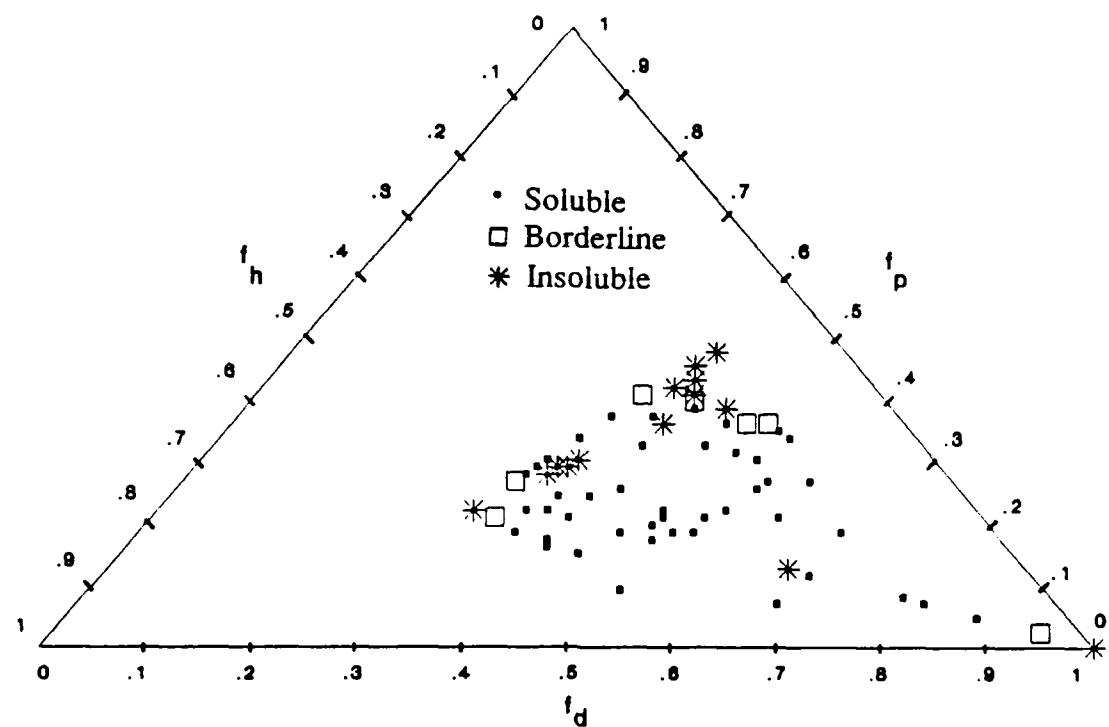


Figure 7. Plot of Teas fractional cohesion parameters on triangular plot.

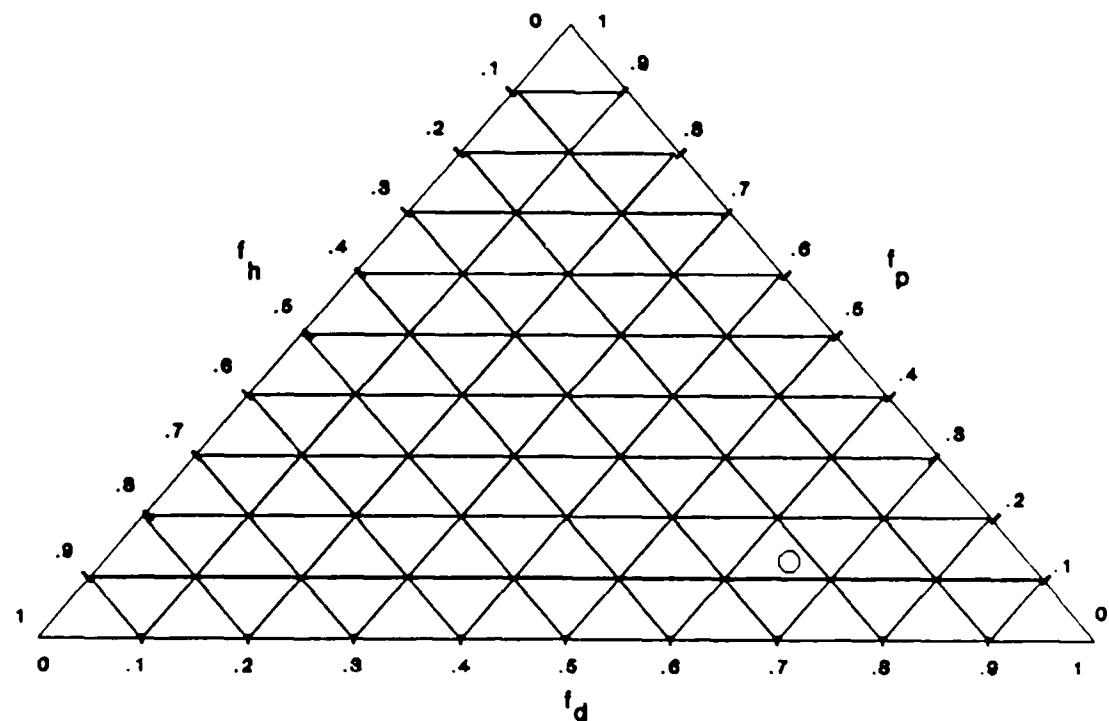


Figure 8. Plot of Teas fractional cohesion contours.

The experimental points in Figure 7 appear to cluster in the lower right hand corner of the plot, corresponding to a high dispersive content and little polar or hydrogen bonding contribution, and, indeed, this is to be expected for most liquids. A solubility border is roughly indicated by the line extending from (0.3, 0.2, and 0.5) to (0.4, 0.5, and 0.1). The borders along the other two axes are not as clearly defined.

Figure 9 shows the general solubility region, as depicted in Figure 1, along with the previously determined⁹ duPont solubility map for poly(isobutylmethacrylate). The area of overlap for the two solubility regions is large, presumably because the isobutylmethacrylate component is in large excess (75%) in the copolymer. The two components of the copolymer are both methacrylate esters, differing only in their alkyl groups and one of the alkyl groups contains an amino group. Despite the similarities in the solubility maps, there is an area characterized by a high solubility parameter and intermediate to high hydrogen bonding, in which only the copolymer is soluble. Solvents whose coordinates lie in this region are dimethylformamide, N,N-dimethylacetamide and N-methylpyrrolidone.

According to the duPont⁹ map, poly(iBMA) would not be soluble in these solvents; however, it is known* that poly(iBMA) is soluble in both DMF and N-methylpyrrolidone. The reason for this discrepancy can probably be attributed to the three-dimensional nature of the solubility diagram. The third parameter of interest with regard to the solubility map is the dipole moment. The duPont solubility map⁹ for the iBMA polymer was determined for solvents of low to intermediate dipole moment. Apparently, the solubility of poly(iBMA) is enhanced at higher values of the dipole moment. This can be envisioned as larger contours at increasing dipole moment values. In other words, poly(iBMA) is probably not soluble in liquids which have the same solubility parameter and hydrogen bond index as DMF, but a smaller dipole moment.

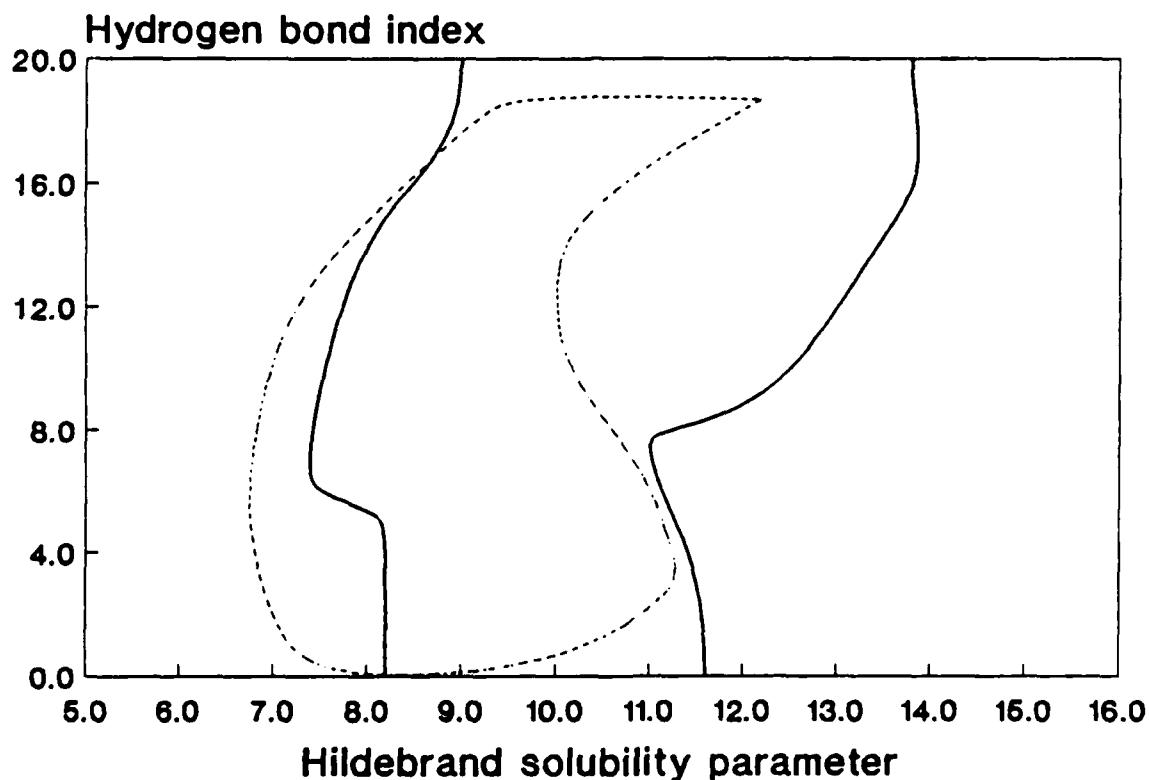


Figure 9. Plot of solubility contours for copolymer (—) and iBMA (....).

* HONG, S. H. and SHUELY, W. J. U.S. Army Chemical Research, Development, and Engineering Center, Aberdeen Proving Ground, MD. Private Communication.

9. duPont de Nemours, E. I. and Company. *Solvent Formulating Maps for Elvacite Acrylic Resins*. Bulletin PA-12-174, A-88130, Wilmington, DE, 1974.

Both the iBMA homopolymer and the iBMA/tBAEMA copolymer are soluble in most alcohols, which typically have high hydrogen bond indices and intermediate solubility parameters (e.g., n-propanol, with a solubility parameter of 11.9 and a hydrogen bonding index of 18.7). However, only the copolymer is soluble in ethanol, which has the same hydrogen bond index but a higher solubility parameter (12.7). Methanol, on the other hand, which has the same hydrogen bonding ability but an even higher solubility parameter of 14.5, is not a solvent for either the copolymer or the poly(iBMA). Even though the alcohols have similar structure, apparently the increasing cohesion as the size of the n-alkyl groups decreases, changes the solubility properties significantly.

Calculation of Solubility Parameters

Since polymers usually cannot be volatilized without decomposing, solubility parameters cannot generally be calculated from heats of vaporization. Group contribution methods have been developed to calculate solubility parameters of polymers and have worked quite well. Using the values of Hoy,¹⁰ the solubility parameters of the two homopolymers poly(iBMA) and poly(tBAEMA) can be calculated by the following equation

$$\delta = d \sum G / M \quad (6)$$

where d is the density of the polymer, G is the group molar contribution for each functional group in the polymer repeat unit, and M is the molecular weight of the repeat unit.

Figure 10 shows the repeat units of the copolymer and the group molar contributions for each functional group. Assuming that the densities of the two homopolymers and the copolymer are the same (estimated to be 1.1 g/mL), the calculated solubility parameters for the polymers are as follows:

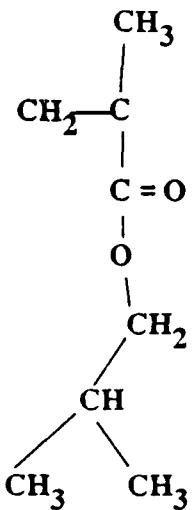
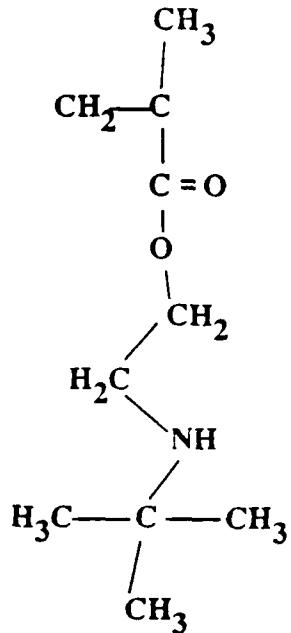
poly(iBMA): 8.9

poly(tBAEMA): 9.2

poly(iBMA-co-tBAEMA), 75/25: 9.0

As is apparent from Figure 9 the copolymer has a slightly larger solubility parameter than the isobutylmethacrylate polymer, probably due to a higher solubility parameter for the tBAEMA component. This is confirmed by the above calculations. These calculations are probably not too accurate, but the general trends can be seen. Indeed, if the tBAEMA homopolymer and the copolymer have higher densities than the iBMA polymer, then the differences between the calculated solubility parameters of the iBMA homopolymer and the copolymer would be even greater.

10. HOY, K. L. *J. Paint Technology*, V. 42, 1970, p. 76.

iBMA, $M = 142.20 \text{ g/mol}$ tBAEMA, $M = 185.27 \text{ g/mol}$ 

IBMA	Group Contributions, G	tBAEMA
3	-CH ₃ (147.3)	4
2	-CH ₂ - (131.5)	3
1	>C< (32.03)	2
1	-COO- (326.58)	1
1	-CH< (180.03)	0
0	-NH- (180.03)	1

1149.50

1554.37

Figure 10. Repeat unit structures for copolymer and group molar contributions to solubility parameter.

CONCLUSIONS

The solubility map for poly(iBMA-co-tBAEMA) of composition 77:23 has been determined for the coordinates of Hildebrand solubility parameter and hydrogen bond index. In addition, portions of the solubility regions have been determined in the Hansen solubility parameter system, as well as in the Teas fractional cohesion parameter system. The range of solvents for this copolymer is significantly greater than that of the homopolymer iBMA which is the co-monomer in greater abundance. The amino group in the tBAEMA unit apparently enhances the solubility of the copolymer in solvents of high solubility parameter and hydrogen bonding ability in which a simple alkylmethacrylate, such as poly(iBMA), is insoluble.

Solubility maps, or phase diagrams, can be used successfully to determine areas of solubility for polymers in selected solvents and solvent mixtures. The determination of an exact

borderline for solubility/insolubility is not feasible using this method and, obviously, any solvent chosen for solution studies based on location on a solubility map should be checked for solubility individually. A general solubility region, however, can be constructed to serve as a guideline for solvent selection, and this should be particularly helpful in the selection of cosolvents in which one or more of the solvents individually is not a solvent. The method used in this study to detect solubility of a polymer solution (visual inspection) is only an indication of macroscopic solubility and is not necessarily an indication of solubility on the molecular level; i.e., polymer solutions can form microgel, which is transparent and would not be detected visually. A more sophisticated test for solubility (such as light transmission) would produce a more reliable test method.

A disadvantage of the solubility test method as applied in this study is the time-consuming, tedious nature of the work. On the other hand, the individual tasks are simple to do, and this makes this type of study an excellent choice for automation/robotics. The processes of weighing out a powder, titrating small volumes of liquid, and using some type of sensor to test for solubility are all tasks well suited for a laboratory robotics system. Possibilities for solubility sensors include machine vision, measuring light transmission to determine transparency, and sampling the solution to monitor concentration.

Future work in our laboratory may be directed toward automating this procedure.

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The author also wishes to thank Mr. Andrew Sullivan for assistance in polymer solution preparation.

APPENDIX A. SOLUBILITY PARAMETERS FOR COMMON SOLVENTS (FROM REFERENCE 3)

	SP*	HBI*	DM*	δ_d^{**}	δ_p^{**}	δ_h^{**}	δ_t^{**}	$100f_d^{*}$	$100f_p^{*}$	$100f_h^{*}$
Acetone	10.0	9.7	2.9	7.6	5.1	3.4	9.8	47.0	32.0	21.0
Acetonitrile	11.9	6.3	3.9	7.5	8.8	3.0	11.9	39.0	45.0	16.0
Benzene	9.2	0.0	0.0	9.0	0.0	1.0	9.1	78.0	8.0	14.0
n-Butanol	11.4	18.7	1.7	7.8	2.8	7.7	11.3	43.0	15.0	42.0
2-Butanone (MEK)	9.3	7.7	2.7	7.8	4.4	2.5	9.3	53.0	30.0	17.0
2-Butoxyethanol	8.9	13.0	1.6	7.8	2.5	6.0	10.2	46.0	18.0	36.0
Chloroform	9.3	1.5	1.2	8.7	1.5	2.8	9.3	67.0	12.0	21.0
Cyclohexane	8.2	0.0	0.0	8.2	0.0	0.1	8.2	94.0	2.0	4.0
Cyclohexanone	9.7	11.7	2.7	8.7	3.1	2.5	9.6	55.0	28.0	17.0
1,2-Dichloroethane	9.8	1.4	1.1	9.3	3.6	2.0	10.2	67.0	19.0	14.0
Dichloromethane	9.7	1.5	1.5	8.9	3.1	3.0	9.9	59.0	21.0	20.0
Dimethylacetamide	10.8	12.3	3.8	8.2	5.6	5.0	11.1			
Dimethylformamide	12.1	11.7	3.8	8.5	6.7	5.5	12.1	41.0	32.0	27.0
Dimethylsulfoxide	12.9	7.7	4.0	9.0	8.0	5.0	13.0	41.0	36.0	23.0
1,4-Dioxane	9.9	9.7	0.4	9.3	0.9	3.6	10.0	67.0	7.0	26.0
Ethanol	12.7	18.7	1.7	7.7	4.3	9.5	13.0	36.0	18.0	46.0
Ethyl acetate	9.1	8.4	1.8	7.7	2.6	3.5	8.8	51.0	18.0	31.0
Ethyl ether	7.4	13.0	1.2	7.1	1.4	2.5	7.6	64.0	13.0	23.0
Ethylene carbonate	14.7	4.9	4.9	9.5	10.6	2.5	14.4			
2-Ethylhexanol	9.5	18.7	1.7	7.8	1.6	5.8	9.9	50.0	9.0	41.0
n-Heptane	7.4	0.0	0.0	7.5	0.0	0.0	7.5	100.0	0.0	0.0
n-Hexane	7.3	0.0	0.0	7.3	0.0	0.0	7.3	100.0	0.0	0.0
Isopropyl ether	6.9	12.3	1.3							
Methanol	14.5	18.7	1.7	7.4	6.0	10.9	14.5	30.0	22.0	48.0
N-Methylpyrrolidone	11.3	10.0 ¹	4.1	8.8	6.0	3.5	11.2	48.0	32.0	20.0
Nitrobenzene	9.8	2.8	4.3	9.8	4.2	2.0	10.8	52.0	36.0	12.0
Nitromethane	12.7	2.5	3.4	7.7	9.2	2.5	12.3	40.0	47.0	13.0

	SP*	HBI*	DM*	δ_d^{**}	δ_p^{**}	δ_h^{**}	δ_t^{**}	$100f_d^{\#}$	$100f_p^{\#}$	$100f_h^{\#}$
n-Pentane	7.0	0.0	0.0	7.1	0.0	0.0	7.1	100.0	0.0	0.0
Phenol	14.5	18.7	1.7	8.8	2.9	7.3	11.8	46.0	15.0	39.0
n-Propanol	11.9	18.7	1.7	7.8	3.3	8.5	12.0	40.0	16.0	44.0
Pyridine	10.7	18.1	2.2	9.3	4.3	2.9	10.6	56.0	26.0	18.0
Tetrahydrofuran	9.1 ²	8.6 ²	1.8	8.2	2.8	3.9	9.5	55.0	19.0	26.0
Toluene	8.9	4.5	0.4	8.8	0.7	1.0	8.9	80.0	7.0	13.0

* ASTM parameters

SP - Hildebrand solubility parameter, (cal/cm³)^{1/2}

HBI - hydrogen bonding index, Crowley units

DM - dipole moment, Debye units

** Hansen solubility parameters, (cal/cm³)^{1/2}

δ_d - dispersive component

δ_p - polar component

δ_h - hydrogen bonding component

δ_t - total solubility parameter

Teas fractional cohesion parameters, unitless

f_d - dispersive component

f_p - polar component

f_h - hydrogen bonding component

¹ estimated (listed in Barton's Handbook as "moderate")

² from Ref. 9

APPENDIX B. EXPERIMENTALLY DETERMINED COPOLYMER SOLUBILITIES

Solvent Mixtures (vol. %)	Sol.	* SP ^{**}	SP ^{**}	HBI ^{**}	DM ^{**}	δ _d ^{##}	δ _p ^{##}	δ _h ^{##}	100* <i>f</i> _d [#]	100* <i>f</i> _p [#]	100* <i>f</i> _h [#]
1 100 Isopropyl ether	I	6.9	12.3	1.3							
2 100 Pentane	I	7.0	0.0	0.0	14.5	0.0	0.0	100.0	0.0	0.0	0.0
3 100 Heptane	I	7.4	0.0	0.0	15.3	0.0	0.0	100.0	0.0	0.0	0.0
4 45 Isopropyl ether	B	7.4	6.7	0.9							
45 Heptane											
10 Cyclohexanone											
5 100 Ethyl ether	I	7.4	13.0	1.2	14.5	2.9	5.1	64.0	13.0	23.0	
6 70 Isopropyl ether	B	7.7	12.1	1.7							
30 Cyclohexanone											
7 67 Isopropyl ether	S	7.8	12.1	1.8							
33 Cyclohexanone											
8 35 Isopropyl ether	S	8.0	7.2	1.3							
35 Heptane											
30 Acetone											
9 100 Cyclohexane	B	8.2	0.0	0.0	16.8	0.0	0.2	94.0	2.0	4.0	
10 30 Isopropyl ether	B	8.2	4.8	2.1							
30 Heptane											
40 Nitrobenzene											

Solvent Mixtures (vol. %)	Sol. *	SP**	HBI**	DM**	$\delta_d^{##}$	$\delta_l^{##}$	$\delta_h^{##}$	$100*f_d^{\#}$	$100*f_p^{\#}$	$100*f_h^{\#}$
11 48 Isopropyl ether	S	8.2	9.8	1.8						
12 12 Heptane										
12 40 Acetone										
12 50 2-Ethylhexanol	B	8.2	15.5	1.5						
12 50 Isopropyl ether										
13 50 2-Ethylhexanol	B	8.2	15.5	1.5						
13 50 Isopropyl ether										
14 30 Isopropyl ether	S	8.3	7.6	1.6						
14 30 Heptane										
14 40 Acetone										
15 28 Isopropyl ether	S	8.4	7.7	1.7						
15 28 Heptane										
15 45 Acetone										
16 50 Isopropyl ether	S	8.5	11.0	2.1						
16 50 Acetone										
17 56 Toluene	S	8.6	2.5	0.2	17.5	0.8	1.2	86.2	4.8	9.0
17 44 Cyclohexane										
18 25 Isopropyl ether	S	8.6	7.9	1.8						
18 25 Heptane										
18 50 Acetone										
19 45 Isopropyl ether	S	8.6	10.9	2.2						
19 55 Acetone										
20 100 Toluene	S	8.9	4.5	0.4	18.0	1.4	2.0	80.0	7.0	13.0

Solvent Mixtures (vol. %)	Sol. [*]	SP ^{**}	HBI ^{**}	DM ^{**}	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	$100*f_d^{\#}$	$100*f_p^{\#}$	$100*f_h^{\#}$	
21 100	2-Butoxyethanol	S	8.9	13.0	1.6	16.0	5.1	12.3	46.0	18.0	36.0
22 80	2-Ethylhexanol	B	9.0	17.4	1.6						
20	Isopropyl ether										
23 100	Tetrahydrofuran	S	9.1	8.4	1.8	15.8	5.3	7.2	51.0	18.0	31.0
24 100	Benzene	S	9.2	0.0	0.0	18.4	0.0	2.0	78.0	8.0	14.0
25 100	Chloroform	S	9.3	1.5	1.2	17.8	3.1	5.7	67.0	12.0	21.0
26 100	2-Butanone	S	9.3	7.7	2.7	16.0	9.0	5.1	53.0	30.0	17.0
27 100	2-Ethylhexanol	S	9.5	18.7	1.7	16.0	3.3	11.9	50.0	9.0	41.0
28 70	Cyclohexanone	S	9.6	13.8	2.4	17.3	5.4	7.1	53.5	22.3	24.2
30	2-Ethylhexanol										
29 60	Cyclohexanone	S	9.6	14.5	2.3	17.1	5.1	7.8	53.0	20.4	26.6
40	2-Ethylhexanol										
30 50	Cyclohexanone	S	9.6	15.2	2.2	16.9	4.8	8.5	52.5	18.5	29.0
50	2-Ethylhexanol										
31 100	Dichloromethane	S	9.7	1.5	1.5	18.2	6.3	6.1	59.0	21.0	20.0
32 45	Acetone	S	9.7	14.7	2.2	15.8	6.5	9.7	48.7	19.3	32.0
55	2-Ethylhexanol										
33 35	Acetone	S	9.7	15.6	2.1	15.8	5.8	10.2	49.0	17.0	34.0
65	2-Ethylhexanol										

Solvent Mixtures (vol. %)	Sol.	SP ^{**}	HBI ^{**}	DM ^{**}	δ _d ^{##}	δ _p ^{##}	δ _h ^{##}	100* <i>f</i> _d [#]	100* <i>f</i> _p [#]	100* <i>f</i> _h [#]	
34 100	1,2-Dichloroethane	S	9.8	1.4	1.1	19.0	7.4	4.1	67.0	19.0	14.0
35 55	Acetone	S	9.8	13.8	2.4	15.7	7.2	9.2	48.4	21.7	30.0
45 55	2-Ethylhexanol										
36 50	Acetone	S	9.8	14.2	2.3	15.8	6.9	9.5	48.5	20.5	31.0
50	2-Ethylhexanol										
37 100	Dioxane	S	9.9	9.7	0.4	19.0	1.8	7.4	67.0	7.0	26.0
38 100	Acetone	S	10.0	9.7	2.9	15.5	10.4	7.0	47.0	32.0	21.0
39 80	Dichloromethane	S	10.1	2.5	2.0	17.6	8.6	6.1	55.0	25.8	19.2
20	Acetonitrile										
40 50	Toluene	S	10.4	5.4	2.2	16.7	9.7	4.0	59.5	26.0	14.5
50	Acetonitrile										
41 60	Dichloromethane	S	10.6	3.4	2.5	17.0	11.0	6.1	51.0	30.6	18.4
40	Acetonitrile										
42 50	Methanol	S	10.7	15.5	1.5						
50	Isopropyl ether										
43 100	Pyridine	S	10.7	18.1	2.2	19.0	8.8	5.9	56.0	26.0	18.0
44 100	Dimethylacetamide	S	10.8	12.3	3.8	16.8	11.5	10.2			
45 46	Acetonitrile	S	10.9	8.1	3.4	15.4	13.9	6.6	43.3	37.9	18.7
54	Acetone										

Solvent Mixtures (vol. %)	Sol. [*]	SP ^{**}	HBI ^{**}	DM ^{**}	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	$100*f_d^{\#}$	$100*f_p^{\#}$	$100*f_h^{\#}$
46 40 Dichloromethane 60 Acetonitrile	S	11.0	4.4	2.9	16.5	13.3	6.1	47.0	35.4	17.6
47 53 Acetonitrile 47 Acetone	B	11.0	7.9	3.4	15.4	14.5	6.5	42.7	38.9	18.3
48 75 Acetonitrile 25 Toluene	B	11.1	5.9	3.0	16.0	13.9	5.1	49.2	35.5	15.3
49 64 Acetonitrile 36 Acetone	I	11.2	7.5	3.5	15.4	15.3	6.4	41.9	40.3	17.8
50 65 Nitromethane 35 Toluene	S	11.4	3.2	2.4	16.6	12.7	4.0	54.0	33.0	13.0
51 83 Acetonitrile 17 Toluene	I	11.4	6.0	3.3	15.8	15.2	5.4	46.0	38.5	15.5
52 100 n-Butanol	S	11.4	18.7	1.7	16.0	5.7	15.8	43.0	15.0	42.0
53 68 Nitromethane 32 Toluene	S	11.5	3.1	2.4	16.5	13.2	4.1	52.8	34.2	13.0
54 80 Acetonitrile 20 Acetone	I	11.5	7.0	3.7	15.3	16.5	6.3	40.6	42.4	17.0
55 71 Nitromethane 29 Toluene	B	11.6	3.1	2.5	16.4	13.7	4.2	51.7	35.3	13.0
56 100 Acetonitrile	I	11.9	6.3	3.9	15.3	18.0	6.1	39.0	45.0	16.0

Solvent Mixtures (vol. %)	Sol.	SP ^{**}	HBI ^{**}	DM ^{**}	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	$1000 \cdot f_d^{##}$	$1000 \cdot f_p^{##}$	$1000 \cdot f_h^{##}$
57 90 Acetonitrile 10 n-Propanol	1	11.9	7.5	3.7	15.4	16.9	7.2	39.1	42.1	18.8
58 72 Acetonitrile 28 n-Propanol	S	11.9	9.8	3.3	15.5	14.9	9.3	39.3	36.9	23.8
59 100 n-Propanol	S	11.9	18.7	1.7	16.0	6.8	17.4	40.0	16.0	44.0
60 100 Dimethylformamide	S	12.1	11.7	3.8	17.4	13.7	11.3	41.0	32.0	27.0
61 50 Methanol 50 Cyclohexanone	S	12.1	15.2	2.2	16.5	9.3	13.7	42.5	25.0	32.5
62 80 Acetonitrile 20 Methanol	B	12.4	8.8	3.5	15.3	16.9	9.3	37.2	40.4	22.4
63 34 Ethyl <i>t</i> , <i>c</i> Carbonate 33 Ethanol 33 Cyclohexanone	S	12.4	11.7	3.1	17.7	12.4	9.8			
64 32 Ethylene Carbonate 24 Methanol 44 Acetone	S	12.6	10.3	3.3	16.7	14.5	10.0			
65 60 Methanol 40 Cyclohexanone	S	12.6	15.9	2.1	16.2	9.9	15.4	40.0	24.4	35.6
66 100 Nitromethane	I	12.7	2.5	3.4	15.8	18.8	5.1	40.0	47.0	13.0
67 8 Acetone 92 Dimethylsulfoxide	I	12.7	7.9	3.9	18.2	15.9	9.9	41.5	35.7	22.8

Solvent Mixtures (vol. %)	Sol.*	SP**	HBI**	DM**	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	$100*f_d^{##}$	$100*f_p^{##}$	$100*f_h^{##}$
68 100	Ethanol	S	12.7	18.7	1.7	15.8	8.8	19.4	36.0	18.0
69 64	Acetonitrile	S	12.8	10.8	3.1	15.2	15.9	11.9	35.8	36.7
36	Methanol									27.5
70 80	Ethanol	S	12.8	17.7	1.7	16.3	8.3	17.9	39.3	17.6
6	Dichloroethane									43.1
14	Phenol									
71 100	Dimethylsulfoxide	I	12.9	7.7	4.0	18.4	16.4	10.2	41.0	36.0
72 70	Methanol	S	13.1	16.6	2.0	15.9	10.5	17.1	37.5	23.8
30	Cyclohexanone									38.7
73 40	Ethylene Carbonate	I	13.2	10.5	3.3	16.9	15.5	10.8		
30	Acetone									
30	Methanol									
74 50	Methanol	S	13.2	12.5	2.8	15.2	15.2	14.2	34.5	33.5
50	Acetonitrile									32.0
75 46	Ethylene Carbonate	I	13.3	11.7	3.3	17.6	14.5	11.5		
45	Ethanol									
9	Cyclohexanone									
76 75	Methanol	S	13.3	14.4	1.6	16.1	11.1	17.7	39.3	21.3
25	Dichloroethane									39.5
77 34	Ethylene Carbonate	B	13.4	14.0	2.8	17.0	13.2	14.6		
66	Ethanol									

Solvent Mixtures (vol. %)	Sol.	SP ^{**}	HBI ^{**}	DM ^{**}	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	100*f _d [#]	100*f _p [#]	100*f _h [#]
78 36 n -Propanol	1	13.5	11.5	3.4	17.8	14.9	11.2			
12 Ethanol										
53 Ethylene Carbonate										
79 58 Ethanol	1	13.5	12.9	3.0	17.3	14.2	13.4			
42 Ethylene Carbonate										
80 60 Ethylene carbonate	1	13.6	10.4	3.6	18.0	15.7	10.1			
40 n -Propanol										
81 45 Ethylene Carbonate	1	13.6	12.5	3.1	17.4	14.6	13.0			
55 Ethanol										
82 45 Methanol	1	13.6	12.7	3.0	16.9	14.6	15.6	36.1	29.7	34.3
55 Dimethylsulfoxide										
83 65 Methanol	S	13.6	14.4	2.5	15.2	14.3	16.6	33.1	30.0	36.8
35 Acetonitrile										
84 80 Methanol	S	13.6	15.2	1.6	15.9	11.3	18.7	37.4	21.4	41.2
20 Dichloroethane										
85 49 Ethylene carbonate	1	13.7	11.9	3.3	17.6	15.1	12.4			
51 Ethanol										
86 50 Methanol	1	13.7	13.2	2.9	16.8	14.4	16.3	35.5	29.0	35.5
50 Dimethylsulfoxide										
87 70 Methanol	S	13.7	15.0	2.4	15.2	14.0	17.4	32.7	28.9	38.4
30 Acetonitrile										

Solvent Mixtures (vol. %)	Sol.	SP**	HBI**	DM**	$\delta_d^{\#}$	$\delta_p^{\#}$	$\delta_h^{\#}$	$100*f_d^{\#}$	$100*f_p^{\#}$	$100*f_h^{\#}$
88 55 Methanol	I	13.8	13.7	2.7	16.6	14.1	16.9	34.9	28.3	36.7
45 Dimethylsulfoxide										
89 85 Methanol	S	13.8	16.1	1.6	15.7	11.6	19.6	35.6	21.6	42.9
15 Dichloroethane										
90 40 Ethanol	B	13.8	18.7	1.7	15.4	10.9	21.1	32.4	20.4	47.2
60 Methanol										
91 60 Methanol	I	13.9	14.3	2.6	16.4	13.9	17.5	34.4	27.6	38.0
40 Dimethylsulfoxide										
92 75 Methanol	S	13.9	15.6	2.2	15.2	13.7	18.2	32.3	27.7	40.0
25 Acetonitrile										
93 80 Methanol	B	14.0	16.2	2.1	15.1	13.4	19.1	31.8	26.6	41.6
20 Acetonitrile										
94 74 Ethylene carbonate	I	14.2	8.5	4.1	18.5	18.3	8.8			
26 Ethanol										
95 100 Methanol	I	14.5	18.7	1.7	15.1	12.3	22.3	30.0	22.0	48.0
96 100 Ethylene Carbonate	I	14.7	4.9	4.9	19.4	21.7	5.1			

* Sol. - Experimentally determined solubilities

S - Soluble

B - Borderline

I - Insoluble

Solvent Mixtures (vol. %)	Sol. *	SP **	HBI **	DM **	$\delta_d^{##}$	$\delta_p^{##}$	$\delta_h^{##}$	$100*f_d^*$	$100*f_p^*$	$100*f_h^*$
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** ASTM parameters

SP - Hildebrand solubility parameter, (cal/cm³)^{1/2}

HBI - hydrogen bonding index, Crowley units

DM - dipole moment, Debye units

Hansen solubility parameters, (MPa)^{1/2}

δ_d - dispersive component

δ_p - polar component

δ_h - hydrogen bonding component

δ_t - total solubility parameter

* Teas fractional cohesion parameters, unitless

f_d - dispersive component

f_p - polar component

f_h - hydrogen bonding component

¹ Estimated (listed in Barton's Handbook as "moderate")

² from Ref. 9

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	Commander, U.S. Air Force Wright Research & Development Center, Wright-Patterson Air Force Base, OH 45433-6523
1	ATTN: WRDC/MLC
1	WRDC/MLLP, M. Forney, Jr.
1	WRDC/MLBC, Mr. Stanley Schulman
	National Aeronautics and Space Administration, Marshall Space Flight Center, Huntsville, AL 35812
1	ATTN: R. J. Schwinghammer, EH01, Dir, M&P Lab
1	Mr. W. A. Wilson, EH41, Bldg. 4612
	U.S. Department of Commerce, National Institute of Standards and Technology, Gaithersburg, MD 20899
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2	Director, U.S. Army Materials Technology Laboratory, Watertown, MA 02172-0001
1	ATTN: SLCMT-TML
1	Author

U.S. Army Materials Technology Laboratory
Watertown, Massachusetts 02172-0001
SOLUBILITY CHARACTERISTICS OF A
METHACRYLATE COPOLYMER.
Marie K. Potts

Technical Report MTL TR 90-28, May 1990, 28 pp-
illus, D/A Project: F18BF8.J2FIAW,
AMCMIS Code: 61110271A0011

Solubility maps in several solubility coordinate systems have been constructed to determine regions of solubility for a methacrylate copolymer. The general methodology followed was that of ASTM D 3132 Test Method for Solubility Range of Resins and Polymers. Over 90 individual solvents and solvent mixtures were tested as solvents for the copolymer in the concentration range 5% - 7.5% w/v. A database on the solubility characteristics of common solvents was created to store and utilize the information. Solvent maps were formulated using the solubility parameter-hydrogen bond index-dipole moment system, the Hansen solubility parameter system, and the Teas fractional cohesion parameter system. Each system is primarily empirical in nature, but has varying degrees of theoretical justification.

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